

Work Order ID 100600-2 Split

April-24-13 9:49:05 AM

\*100600\*

RUSH

Page 1

Item ID: D4543-5

Revision ID:

Item Name: Retainer, Outer, LH

Start Date: 4/24/13 Start Qty: 30.00

Required Date: 5/08/13 Req'd Qty: 30.00

Reference:

Accept

\*N9000040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan: MLS

Date: 13-04-24

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4543

B

100

0.00

\*100\*

Waterjet

FLOW CNC Waterjet

6061 TG .032

Memo

0.00

1- Cut as per dwg

Prog rev: B

Dwg rev: B

2- Deburr

30



13-04-16

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Quality Control

Memo

0.00

30



13-04-20

# Work Order ID 100600

April-24-13 9:49:05 AM

\*100600\*

Page 2

Item ID: D4543-5

Revision ID:

Item Name: Retainer. Outer. LH

Start Date: 4/24/13

Start Qty: 30.00

Required Date: 5/08/13

Req'd Qty: 30.00

Reference:

Accept

\*N900040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Quality Control

Memo

0.00

27  
13-4 25

30

130

0.00

\*130\*

Small Fab

Memo

0.00

Small Fab

FORM ON BEAD ROLLER (DT9787)

8

8

FF  
13-04-26

140

QC5- Inspect part completeness to step on W/O

0.00

\*140\*

QC

Quality Control

Memo

0.00

27  
13-4 26

8

Checked  
against  
template.  
OK 4/13/13



# Work Order ID 100600

April-24-13 9:49:05 AM

\*100600\*

Page 3

Item ID: D4543-5

Revision ID:

Item Name: Retainer, Outer, LH

Start Date: 4/24/13 Start Qty: 30.00

Required Date: 5/08/13 Req'd Qty: 30.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

\*150\*

HandFinish

Memo

0.00

Hand Finishing

8 1613429

160

QC7-Inspect Chemical Conversion Coat

0.00

\*160\*

QC

Memo

0.00

Quality Control

QAS  
27  
134.29

8

170

Identify as per dwg & Stock Location:

0.00

\*170\*

Packaging

Memo

0.00

Packaging

SHIP

6/3/13 @

Work Order ID 100600

April-24-13 9:49:05 AM

\*100600\*

Page 4

Item ID: D4543-5

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Retainer, Outer, LH

Stop \*NS2\*

Start Date: 4/24/13 Start Qty: 30.00

\*30\*

Cust Item ID:

Required Date: 5/08/13 Req'd Qty: 30.00

\*30\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

\*180\*

QC

Memo

0.00

Quality Control

13/5/6

mf

13-4-30



# Picklist Print

April-24-13 9:19:09 AM

Page 1

Work Order ID: 100600

Parent Item: D4543-5

Parent Item Name: Retainer, Outer, LJI

\*100600\*

\*D4543-5\*

Start Date: 4/24/13

Required Date: 5/08/13

Start Qty: 30.00

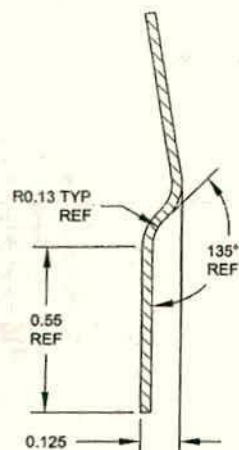
Required Qty: 30.00

Comments: IPP REV:A 13.04.23 as per dwg revB DD verf:JLM

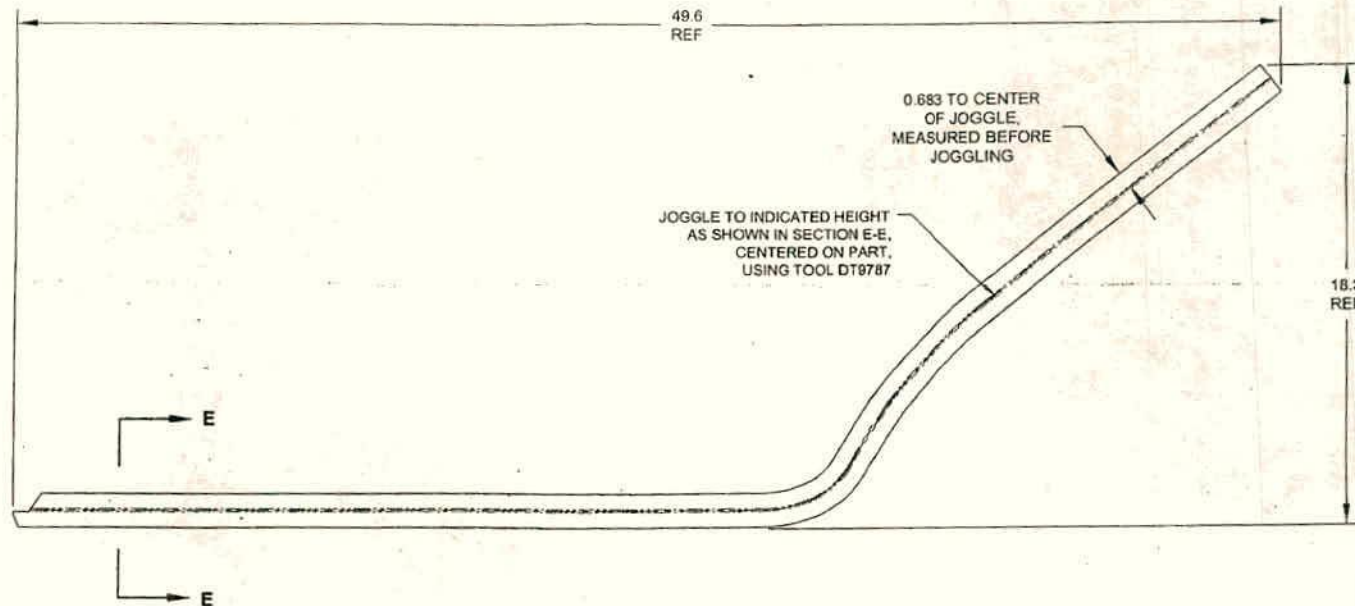
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	1,183.770	2	63.15789			
									**				
*M6061T6S 0.32*													
6061-T6 Sheet 0.032"													

W 13.04.25

Location	Loc Qty	Loc Code
MAT021	1183.77	
121099	171.94	
122256	46.78	
122737	44.8	
123097	71.9	
123135	37.7	
123137	51.85	
123293	58.5	
123483	260.6	
123701	47.85	
124629	199.85	
125341	192	



**SECTION E-E**  
JOGGLE DETAIL  
SCALE 12X



**D4543-5 RETAINER, LH OUTER**  
(SIDE/TOP) B

**NOTES:**

- 1) MATERIAL: MAKE FROM D4543-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

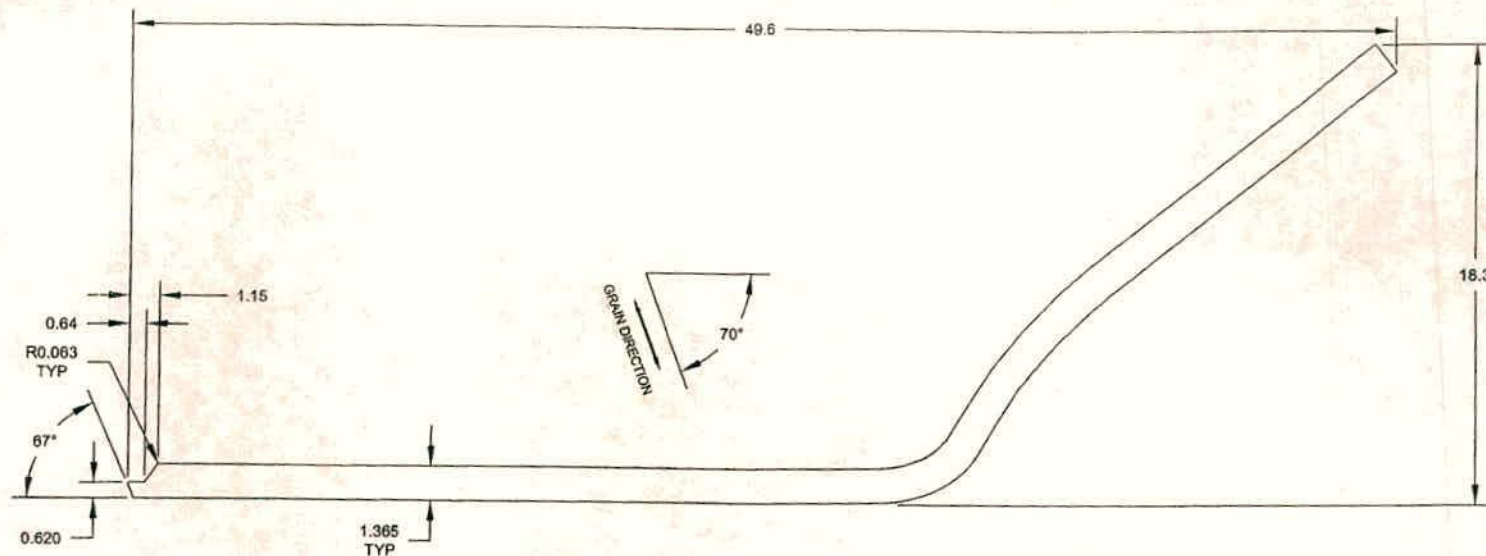
DESIGN	<i>Q</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>Q</i>		
CHECKED	<i>Q</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>Q</i>	D4543	SHEET 7 OF 9
APPROVED	<i>Q</i>	TITLE	SCALE
DE APPR.	<i>Q</i>	RETAINER, OUTER	NTS
DATE	13.04.15	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. IT IS TO BE KEPT IN THE STRICTEST CONFIDENCE AND IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

**RELEASED**  
2013-04-22

100.600 MJS  
13-04-24



100600



**D4543-5F FLAT PATTERN**



**RELEASED**  
2013-04-22

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC. M8061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.24 lbs
- 8) PROFILE PER DRAWING FILE "D4543-5F-REV-B.DXF"

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4543	SHEET 9 OF 9
APPROVED		TITLE	SCALE
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